



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3488-041**  
**Job Sheet 169883**



Part No: D3488-041

Job Qty: 6 ea

Part Name: Blade Fitting LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/12/18

Description:

Note: DWG DSK101 REV D, D3488 REV B IPP Rev:A New Issue 06-02-28 JLM IPP Rev:B As per Rev B 06-03-30  
JLM IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation     | 6 Ea  | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Start Up Machining-2  |           |          |
| 100   | Doosan                 | 6 pcs | 1/11/18    | 1/11/18  | 0.00      | 5.13    | Doosan                |           |          |
| 110   | QC                     | 6 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC2 Machining-2       |           |          |
| 120   | CNC Vertical Machining | 6 pcs | 1/11/18    | 1/11/18  | 0.34      | 4.96    | HAAS1-3               |           |          |
| 130   | QC                     | 6 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC2 Machining-2       |           |          |
| 140   | QC                     | 6 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.00    | QC8 Machining-2       |           |          |
| 150   | HandFinish             | 6 pcs | 1/11/18    | 1/11/18  | 0.00      | 0.19    | HandFinish1           |           |          |
| 160   | Powdercoat             | 6 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.21    | Powdercoat1           |           |          |
| 170   | QC                     | 6 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | QC3                   |           |          |
| 180   | HandFinish             | 6 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | HandFinish4           |           |          |
| 190   | QC                     | 6 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | QC5                   |           |          |
| 200   | Packaging              | 6 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | Packaging3-1          | FP001     |          |
| 210   | QC21-SA                | 6 Ea  | 1/12/18    | 1/12/18  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FA625

Descriptions: 120 - 1-Machine as per Folio FA625 & Dwg D3488

160 - START TIME: 1:30pm to 2:00pm 32°f

180 - Install Inserts as per Dwg D3488

200 - LOCATION : FP001

21 MAR 18 2018

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D6103-003      | 6        | 6         | 0         | 0       |
| 180-HandFinish        | ALS7-1032-225  | 24       | 78        | 0         | 0       |

### Part Specifications

Specifications could not be found.

# **DART**

AEROSPACE

## **S040145**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: [sales@dartaero.com](mailto:sales@dartaero.com)  
[www.dartaerospace.com](http://www.dartaerospace.com)



Blade Fitting LH

**PART NO: D3488-041**

**Original Serial #: S040145**

**Revision:**

**Operation:**

**Change No:**

**Start up Operation 02/07/18**

**Job No: 169883**

|                                                                       |                     |                    |
|-----------------------------------------------------------------------|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>                                             | <b>Work Order:</b>  | 169885             |
| <b>Description: Blade Fitting, LH / Turning Detail for D3488-1/-2</b> | <b>Part Number:</b> | D3488-1            |
| <b>Inspection Dwg: D3488 / DSK101 Rev: B / D</b>                      |                     | <b>Page 1 of 2</b> |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension    | Tolerance          | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|--------------------|------------------|--------|--------|----------------------|----------|
| <b>Lathe Section</b> |                    |                  |        |        |                      |          |
| Ø2.150               | +/-0.005           | 2.145            |        |        | Vern LPOS            |          |
| Ø2.780               | +/-0.005           | 2.777            |        |        |                      |          |
| Ø3.125               | +/-0.010           | 3.117            |        |        |                      |          |
| Ø3.346               | +/-0.010           | 3.341            |        |        |                      |          |
| 0.125 x 45°          | +/-0.010 x +/-0.1° | .125 x 45°       |        |        |                      |          |
| 8.000                | +0.030/-0.000      | 8.017            |        |        | Height gauge         |          |
| 9.250                | +/-0.010           | 9.250            |        |        |                      |          |
| 0.188                | +/-0.010           | .188             |        |        |                      |          |
| R0.032               | +/-0.010           | .032             |        |        | Vern LPOS            |          |
| R0.062               | +/-0.010           | .063             |        |        |                      |          |
| Ø0.297               | +0.005/-0.001      | .299             |        |        |                      |          |
| Ø0.430               | +/-0.010           | .427             |        |        |                      |          |
| 0.100                | +/-0.010           | .100             |        |        |                      |          |
| 0.125                | +/-0.010           | .125             |        |        |                      |          |
| 2.620                | +/-0.010           | 2.614            |        |        |                      |          |
| 3.500                | +/-0.010           | 3.500            |        |        | height gauge         |          |
| 1.005                | +/-0.010           | 1.005            |        |        |                      |          |
| Ø0.484               | +0.005/-0.001      | .483             |        |        | Vern LPOS            |          |
| 1.180                | +/-0.010           | 1.180            |        |        | height gauge         |          |
| 3.150                | +/-0.010           | 3.150            |        |        |                      |          |
| 3.070                | +/-0.010           | 3.063            |        |        |                      |          |
| R0.063               | +/-0.010           | .063             |        |        | Vern LPOS            |          |
|                      |                    |                  |        |        |                      |          |
|                      |                    |                  |        |        |                      |          |



|                                                                       |  |                     |                |
|-----------------------------------------------------------------------|--|---------------------|----------------|
| <b>DART AEROSPACE LTD</b>                                             |  | <b>Work Order:</b>  |                |
| <b>Description:</b> Blade Fitting, LH / Turning Detail for D3488-1/-2 |  | <b>Part Number:</b> | <b>D3488-1</b> |
| <b>Inspection Dwg:</b> D3488 / DSK101 <b>Rev:</b> B / D               |  | <b>Page 2 of 2</b>  |                |

| Drawing Dimension      | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------|---------------|------------------|--------|--------|----------------------|----------|
| <b>Milling Section</b> |               |                  |        |        |                      |          |
| Ø0.508                 | +0.006/-0.001 | .508             | ✓      |        | P.G.                 |          |
| 0.750                  | +/-0.010      | .750             | ✓      |        | Vern.                |          |
| 1.500                  | +/-0.010      | 1.500            | ✓      |        | Vern.                |          |
| 11.18                  | +/-0.030      | 11.178           | ✓      |        | H.G.                 |          |
| R0.062                 | +/-0.010      | .062             | ✓      |        | R.G.                 |          |
| 0.125                  | +/-0.010      | .125             | ✓      |        | Vern.                |          |
| 0.590                  | +/-0.010      | .583             | ✓      |        | H.G.                 |          |
| 0.793                  | +/-0.010      | .796             | ✓      |        | Vern.                |          |
| 1.351                  | +/-0.010      | 1.350            | ✓      |        | H.G.                 |          |
| 1.317                  | +/-0.010      | 1.315            | ✓      |        | Vern.                |          |
| 1.802                  | +/-0.010      | 1.803            | ✓      |        | H.G.                 |          |
|                        |               |                  |        |        |                      |          |
|                        |               |                  |        |        |                      |          |
|                        |               |                  |        |        |                      |          |

|                                  |                    |                            |     |
|----------------------------------|--------------------|----------------------------|-----|
| <b>Measured by:</b> P/SBL        | <b>Audited by:</b> | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 16-02-07 / 18/02/17 | <b>Date:</b>       | <b>Date:</b>               | N/A |

| Rev | Date     | Change                  | Revised by | Approved |
|-----|----------|-------------------------|------------|----------|
| A   | 06.03.31 | New Issue               | KJ/JLM     |          |
| B   | 08.09.19 | Reformat P/O D3488-041  | KJ/JLM     |          |
| C   | 08.12.02 | Dimension 8.000 removed | KJ/JLM     |          |